INSTALLATION

INSTRUCTIONS

No. 1 EMMERT UNIVERSAL VISE

First, open the jaws until they run off the screw, so that you can remove the front jaw and beam from the vise. This will leave you the hinge plate and back jaw assembly to handle while mounting.

Next, you want to place the back jaw and hinge plate assembly on the edge of the bench so that you can outline the hinge plate on the top and front edge of the bench in order to cut out, so that the hinge plate will be flush with the top of the bench and front edge of the bench. The size of the hinge plate that mounts on the top of the bench should be 7-$\frac{1}{4}$" x 3-3/4". This is the part #1-K-12 on the enclosed parts list. Now if your bench is over 1-3/4" thick you will have to cut out a radius clearance on the bottom of the bench to clear the hub, which is part #1-K-3; if your bench is thinner, this will not be necessary. As far as screws are concerned, if your bench is 1-$\frac{1}{4}$" or thicker, a #14-1$\frac{1}{2}$" wood screw should be used on the top of the hinge plate and also on the front edge of the bench. If your bench is less than 1-$\frac{1}{4}$" in thickness use a counter-sunk flat head machine screw with nuts in the section of hinge plate on the top of the bench and use the #14 - 1-$\frac{1}{2}$" wood screw going into the edge of the bench.

At this point you have your back jaw and hinge plate assembly mounted on the bench. Now put your front jaw assembly back on. You are now complete except for installation of your rack bar, which controls the 90 degree tilt action. This shows on the parts list as #1-K-43 and #1-K-44; attach #1-K-43 to the vise and then slide the #1-K-44 assembly on to #1-K-43 with this bar going through the slot shown as part #1-K-4. Part #1-K-44 should now be screwed to the bottom of the bench in a position so that #1-K-43 will be lined up straight and also the bracket should be in a position to allow a full 90 degree movement of the vise. To do this the front edge of #1-K-44 should be 5" back from the front edge of the bench and after it is straight it should be approximately 2-3/4" to the left of the center of the beam #1-K-7 to the nearest edge of #1-K-44.